

Tuesday, 13/01/2009 9:22:19 AM

User:

Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	REAR OVERHEAD R/H
<b>Job Number</b> :	44719		
<b>Estimate Number</b> :	13590		
<b>P.O. Number</b> :		<b>Part Number</b> :	D38232
<b>This Issue</b> :	13/01/2009	<b>Drawing Number</b> :	D38232 UNDER REVIEW <i>OK upto step 9</i>
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	IN0002
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	A UNDER REVIEW
<b>Previous Run</b> :	43180	<b>Material</b> :	MKYD6185S080P362015
<b>Written By</b> :		<b>Due Date</b> :	20/01/2009
<b>Checked &amp; Approved By</b> :	<i>JUD 29.01.13</i>	<b>Qty:</b>	2 Um: Each
<b>Comment</b> :	Est. A New Issue 08/09/17 DL		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MKYD6185S080P362015

6185 KYDEX .080"



109703

M 109703



**Comment:** Qty.: 11.3747 sf(s)/Unit. Total : 22.7493 sf(s)  
6185 Kydex .080"

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

*BB 09/01/14*

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

*BB 09/01/14 (X2 +2)*

4.0

THERMOFORMING

THERMOFORMING MACHINE

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-2 and folio (FTA 9113 Prototype ) using tool DT 9113

Dwg. Rev. *A*Folio Rev. *A*
*BB 09/01/14 (X2 +2)*

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

*BB 09/01 (X2 +2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD R/H

Job Number: 44719

Part Number: D38232

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 09-01-19

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/02/18 (X1)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/02/18 (X1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 09/04/14  
**ENGINEERING  
APPROVAL**

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

09/04/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



W 09/04/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.01.14	7	<del>DIMENSION "0.44 MIN" IS</del> N/A PAR 09.04.15						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44719
Description: Rear overhauled R/H		Part Number: D3823-2
Inspection Dwg: D3823	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			

Measured by: [Signature] Date: 09-02-23

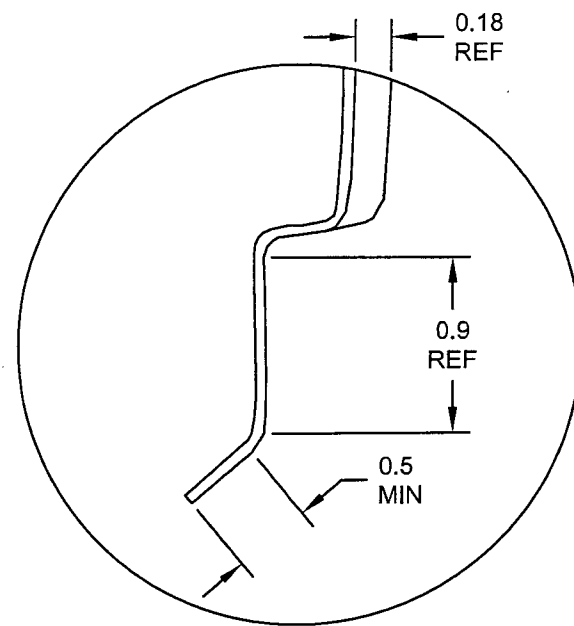
### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.18 (Ref)		0.38				Revise ??
0.9 (Ref)		0.93	/		vern.	
0.5 (Ref)	min.	0.53	/		vern.	
1.75	min	1.76	/		vern.	
0.44	min	0.46	/		vern.	
35.94 (Ref)		35.9	/		Tape	
14.3 (Ref)		14.25	/		tape.	
0.045	min mat thick	0.54	/		mic.	

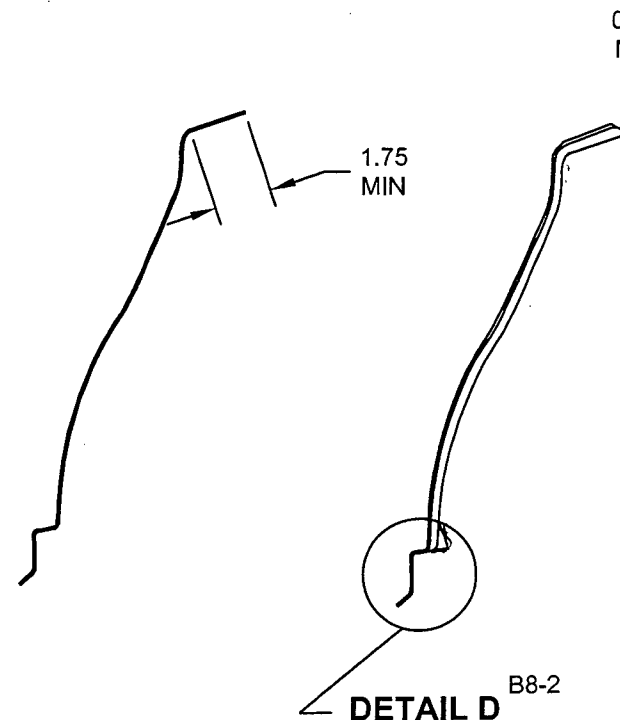
OIC  
SEE  
UPDATED  
DWG  
#  
090414

Measured by: [Signature] Date: 09-02-23  
Audited by: [Signature] Date: 09/04/15  
Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

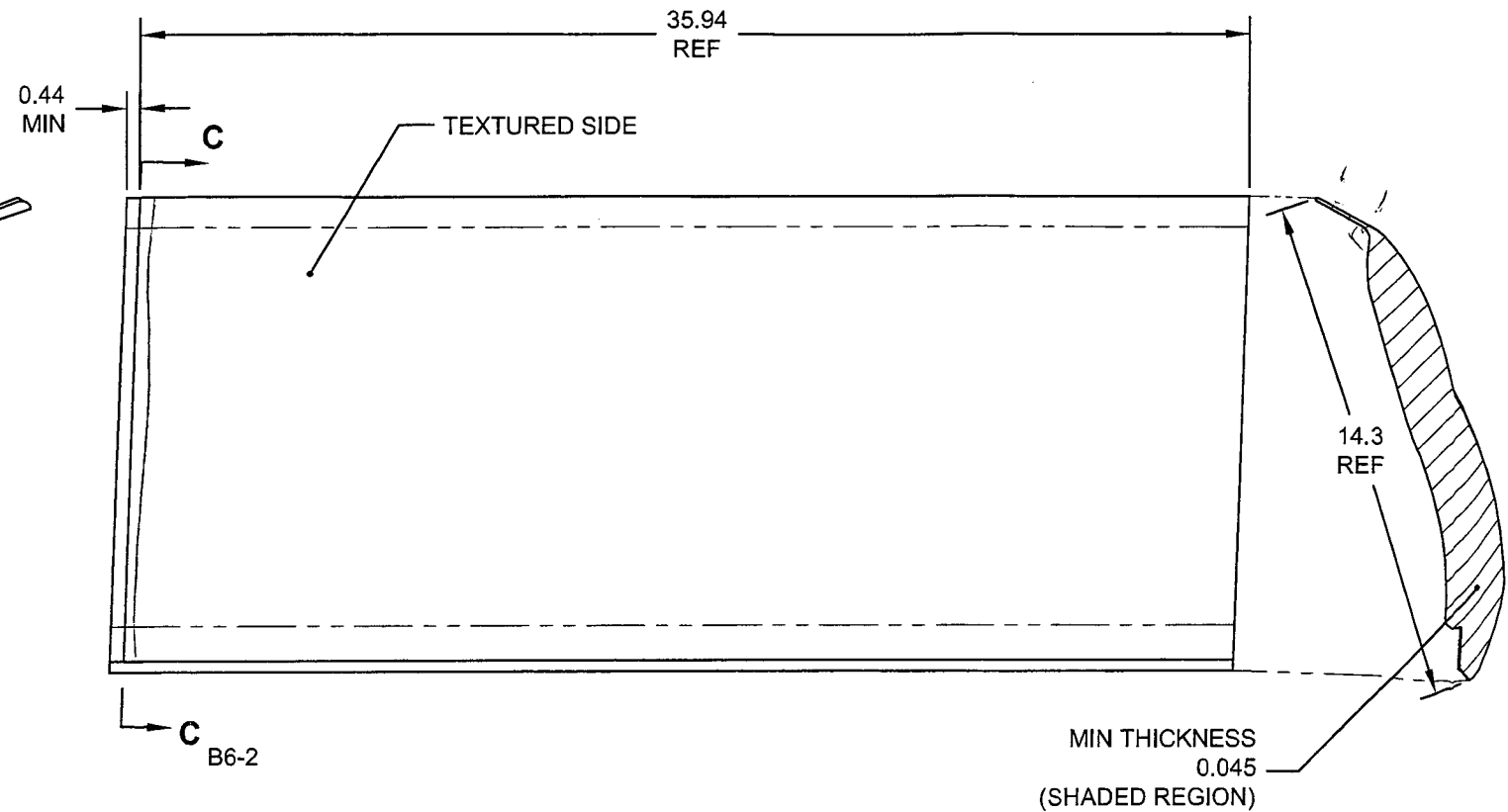
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



**DETAIL D**  
SCALE 5X



**SECTION C-C**



**D3823-2 REAR OVERHEAD, RH**

**NOTES:**

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3823	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	08.09.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

44719  
RELEASED  
09/01/12

